

ASAP

Work Order ID 63026

Monday, October 18, 2010 10:24:29 AM



Item ID: D350-591-133

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Maintenance Step

Start Date: 10/18/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 10/25/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2946

Rev.B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-133 CHG003

[Signature]
~~10.10.21~~

8/10/10/27

[Signature] for BG 10-10-26 (5)

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946

[Signature] 10.10.21

5 *[Signature]*

2-Deburr

Ensure that 57.09" minimum extrusion is kept and identify to be used for D350-591-215/-216.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 63026

Monday, October 18, 2010 10:24:29 AM

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5

10/10/21

130

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Deburr and Bevel ends for welding

2-Weld (1) End Cap and (2) Lugs using Jig DT8440 as per Dwg D2946

A/RAluminum Rod M108436

M114871

3-Grind End Cap welds flush

10.10.21

5

10/10/21

140

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

5 - 10/10/21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 63026

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Revision ID:

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Start Date: 10/18/2010 Start Qty: 5.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5

10/10/21

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

= 2 1/2

10/10/21

5 2

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10.10.21

5 1

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Large Fab

Large Fab

0.00

10.10.22

5

φ

Memo

0.00

Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush.

A/R AL ROD BATCH: 1108436

190



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

5

0

3E10/10/25

Memo

0.00

200



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/10/25

+5

Memo

0.00

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

Chemical Conversion Coat per QSI005 4.1

0.00 BR 10-10-25.



HandFinish

Memo

0.00

Hand Finishing

5

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00 BL 10-10-25.



Powdercoat

M115291

Memo

0.00

Powder Coating

START TIME: 2:35
OVEN TEMPERATURE: 320°
FINISH TIME: 2:05.

5

230

Wing Walk as per dwg QSI005 4.4 Batch M1157900

0.00 74 10/10/25



HandFinish

Memo

0.00

Hand Finishing

5

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NOTE: Date & initial all entries

[illegible]

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Accept

**Setup Start**

Stop

**Cust Item ID:**

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

| Accept | Qty |
|--------|-----|
|--------|-----|

Reject
QtyReject
Number

**Insp.
Stamp**

QC3- Inspect Part Finish

0.00 1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100 101 102 103 104 105 106 107 108 109 110 111 112 113 114 115 116 117 118 119 120 121 122 123 124 125 126 127 128 129 130 131 132 133 134 135 136 137 138 139 140 141 142 143 144 145 146 147 148 149 150 151 152 153 154 155 156 157 158 159 160 161 162 163 164 165 166 167 168 169 170 171 172 173 174 175 176 177 178 179 180 181 182 183 184 185 186 187 188 189 190 191 192 193 194 195 196 197 198 199 200 201 202 203 204 205 206 207 208 209 210 211 212 213 214 215 216 217 218 219 220 221 222 223 224 225 226 227 228 229 230 231 232 233 234 235 236 237 238 239 240 241 242 243 244 245 246 247 248 249 250 251 252 253 254 255 256 257 258 259 260 261 262 263 264 265 266 267 268 269 270 271 272 273 274 275 276 277 278 279 280 281 282 283 284 285 286 287 288 289 290 291 292 293 294 295 296 297 298 299 300 301 302 303 304 305 306 307 308 309 310 311 312 313 314 315 316 317 318 319 320 321 322 323 324 325 326 327 328 329 330 331 332 333 334 335 336 337 338 339 340 341 342 343 344 345 346 347 348 349 350 351 352 353 354 355 356 357 358 359 360 361 362 363 364 365 366 367 368 369 370 371 372 373 374 375 376 377 378 379 380 381 382 383 384 385 386 387 388 389 390 391 392 393 394 395 396 397 398 399 400 401 402 403 404 405 406 407 408 409 410 411 412 413 414 415 416 417 418 419 420 421 422 423 424 425 426 427 428 429 430 431 432 433 434 435 436 437 438 439 440 441 442 443 444 445 446 447 448 449 450 451 452 453 454 455 456 457 458 459 460 461 462 463 464 465 466 467 468 469 470 471 472 473 474 475 476 477 478 479 480 481 482 483 484 485 486 487 488 489 490 491 492 493 494 495 496 497 498 499 500 501 502 503 504 505 506 507 508 509 510 511 512 513 514 515 516 517 518 519 520 521 522 523 524 525 526 527 528 529 530 531 532 533 534 535 536 537 538 539 540 541 542 543 544 545 546 547 548 549 550 551 552 553 554 555 556 557 558 559 560 561 562 563 564 565 566 567 568 569 570 571 572 573 574 575 576 577 578 579 580 581 582 583 584 585 586 587 588 589 590 591 592 593 594 595 596 597 598 599 600 601 602 603 604 605 606 607 608 609 610 611 612 613 614 615 616 617 618 619 620 621 622 623 624 625 626 627 628 629 630 631 632 633 634 635 636 637 638 639 640 641 642 643 644 645 646 647 648 649 650 651 652 653 654 655 656 657 658 659 660 661 662 663 664 665 666 667 668 669 670 671 672 673 674 675 676 677 678 679 680 681 682 683 684 685 686 687 688 689 690 691 692 693 694 695 696 697 698 699 700 701 702 703 704 705 706 707 708 709 710 711 712 713 714 715 716 717 718 719 720 721 722 723 724 725 726 727 728 729 730 731 732 733 734 735 736 737 738 739 740 741 742 743 744 745 746 747 748 749 750 751 752 753 754 755 756 757 758 759 760 761 762 763 764 765 766 767 768 769 770 771 772 773 774 775 776 777 778 779 780 781 782 783 784 785 786 787 788 789 790 791 792 793 794 795 796 797 798 799 800 801 802 803 804 805 806 807 808 809 810 811 812 813 814 815 816 817 818 819 820 821 822 823 824 825 826 827 828 829 830 831 832 833 834 835 836 837 838 839 840 841 842 843 844 845 846 847 848 849 850 851 852 853 854 855 856 857 858 859 860 861 862 863 864 865 866 867 868 869 870 871 872 873 874 875 876 877 878 879 880 881 882 883 884 885 886 887 888 889 890 891 892 893 894 895 896 897 898 899 900 901 902 903 904 905 906 907 908 909 910 911 912 913 914 915 916 917 918 919 920 921 922 923 924 925 926 927 928 929 930 931 932 933 934 935 936 937 938 939 940 941 942 943 944 945 946 947 948 949 950 951 952 953 954 955 956 957 958 959 960 961 962 963 964 965 966 967 968 969 970 971 972 973 974 975 976 977 978 979 980 981 982 983 984 985 986 987 988 989 990 991 992 993 994 995 996 997 998 999 1000 1001 1002 1003 1004 1005 1006 1007 1008 1009 1010 1011 1012 1013 1014 1015 1016 1017 1018 1019 1020 1021 1022 1023 1024 1025 1026 1027 1028 1029 1030 1031 1032 1033 1034 1035 1036 1037 1038 1039 104

[illegible]

OC

Memo

0.00

Quality Control

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

QC4- 100% Inspect kits for completeness

0.00



OC

Memo

0.00

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 63026

Monday, October 18, 2010 10:24:29 AM

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Item ID: D350-591-133

Accept

Revision ID:

Item Name: Aft Maintenance Step

Start Date: 10/18/2010 Start Qty: 5.00

Required Date: 10/25/2010 Req'd Qty: 5.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPPD350-591-133

Location:

PPP Rev: NEW-D

0.00

0.00

280



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Monday, October 18, 2010 10:24:28 AM

Page 1

Work Order ID: 63026

Parent Item: D350-591-133

Parent Item Name: Aft Maintenance Step





Start Date: 10/18/2010

Required Date: 10/25/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:B05.10.14 Modified step 10 KJ/EC
IPP Rev:B06.07.19 D2946 @ rev.b EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D2732  Rubber Extrusion | | Manufactured | No | | | | f | 107.5157 | 2 | 10 | | | |
| <div> <div> <p><i>Handwritten:</i> 10/10/21 D2732-030 cut (8) at 3.00" per kit</p> </div> <div> <p><i>Handwritten:</i> mensa 6/10/10/27</p> </div> </div> | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | | ST412 | | | 107.515737 | | | | | | |
| | | | | | 56516 | | 107.515737 | | | | | | |
| D2622-120C  Step Extrusion | | Manufactured | No | | | 110 | Each | 153.4200 | 0.52 | 2.6 | | | |
| <div> <div> <p><i>Handwritten:</i> 56516</p> </div> <div> <p><i>Handwritten:</i> 10.10.21</p> </div> </div> | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | | WA | | | 153.42 | | | | | | |
| | | | | | 55214 | | 3.42 | | | | | | |
| | | | | | 58544 | | 25 | | | | | | |
| | | | | | 61208 | | 125 | | | | | | |
| D2734  Step End Plate | | Manufactured | No | | | 130 | Each | 61.0000 | 2 | 10 | | | |
| <div> <div> <p><i>Handwritten:</i> 5</p> </div> <div> <p><i>Handwritten:</i> 10.10.21</p> </div> </div> | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | | WA | | | 61 | | | | | | |
| | | | | | 60216 | | 1 | | | | | | |
| | | | | | 61209 | | 60 | | | | | | |
| D2944  Step Mounting Plate | | Manufactured | No | | | 130 | Each | 15.0000 | 2 | 10 | | | |
| <div> <div> <p><i>Handwritten:</i> 5+5</p> </div> <div> <p><i>Handwritten:</i> 10.10.21</p> </div> </div> | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | | WA | | | 15 | | | | | | |
| | | | | | 53725 | | 15 | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Monday, October 18, 2010 10:24:29 AM

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Work Order ID: 63026

Parent Item: D350-591-133

Parent Item Name: Aft Maintenance Step

Start Date: 10/18/2010

Required Date: 10/25/2010

Start Qty: 5.00

Required Qty: 5.00

AN4-11A
Bolt

Purchased No 250 Each 408.0000

4 120

Location Loc Qty Loc Code

ST357 408
110382 208
115316 200

M110382

AN4-14A
Bolt

Purchased No 250 Each 121.0000

8 40

Location Loc Qty Loc Code

ST357 105
114752 1
115371 104
ST358 16
113359 16

M110371

AN4-16A
Bolt

Purchased No 250 Each 255.0000

8 40

Location Loc Qty Loc Code

ST360 255
115159 50
115374 105
115422 100

M110109 25X
M115374 105

AN4-7A
Bolt

Purchased No 250 Each 169.0000

2 10

Location Loc Qty Loc Code

ST356 169
113226 119
115373 50

M113226

Monday, October 18, 2010 10:24:29 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Monday, October 18, 2010 10:24:29 AM

Page 3

Work Order ID: 63026

Parent Item: D350-591-133

Parent Item Name: Aft Maintenance Step

Start Date: 10/18/2010

Required Date: 10/25/2010

Start Qty: 5.00

Required Qty: 5.00

AN0601D416 NAS1149D0463J Purchased No

250 Each

24.0000 14 70



Washer



1115622

Location

Loc Qty

Loc Code

ST300

24

113288

24

D2230-1 Manufactured No

250 Each

19.0000 4 20



Lug



62688

Location

Loc Qty

Loc Code

ST476

19

61713

19

D2230-3 Manufactured No

250 Each

2.0000 4 20



Lug



61647

Location

Loc Qty

Loc Code

ST476

2

55452

2

D2856-400 Manufactured No

250 f

235.4160 1.26 6.3



Abraison Strip



10/10/27(5)

Location

Loc Qty

Loc Code

ST403

235.4160421

56626

51.0960421

59920

184.32

59920

(2X) 4.00" X 7.20" per dwg

Monday, October 18, 2010 10:24:29 AM

Shop Packet Print

Page 3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Monday, October 18, 2010 10:24:29 AM

Page 4

Work Order ID: 63026

Parent Item: D350-591-133

Parent Item Name: Aft Maintenance Step

Start Date: 10/18/2010

Required Date: 10/25/2010

Start Qty: 5.00

Required Qty: 5.00

D2945

Manufactured No

250

Each

15.0000



Step Mounting Plate

Location

Loc Qty

Loc Code

ST031

15

55064

15

MS21042L4

Purchased No

250

Each

3,800.000



Nut

Location

Loc Qty

Loc Code

ST300

3800

113422

68

114523

8

114718

16

114784

32

115108

676

115589

1900

115621

1100

M113722 1100

M114784 32X
M115108 28X

Monday, October 18, 2010 10:24:29 AM

Shop Packet Print

Page 4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

D2946 STEP ASSEMBLY PARTS LIST

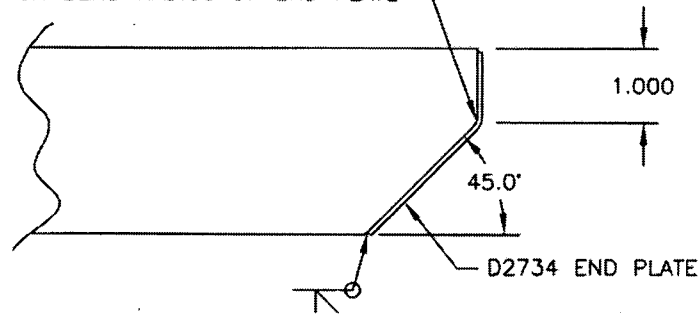
| Part No. | Description | QTY |
|----------|---------------------|-----|
| D2946 | Step Assembly | X |
| D2622-63 | STEP EXTRUSION* | 1 |
| D2734 | END PLATE | 2 |
| D2944 | STEP MOUNTING PLATE | 2 |

*cut per drawing

NOTE: ALL WELDS SHALL BE
100% VISUALLY
INSPECTED BY A
QUALIFIED INSPECTOR
PER DART QSI 004

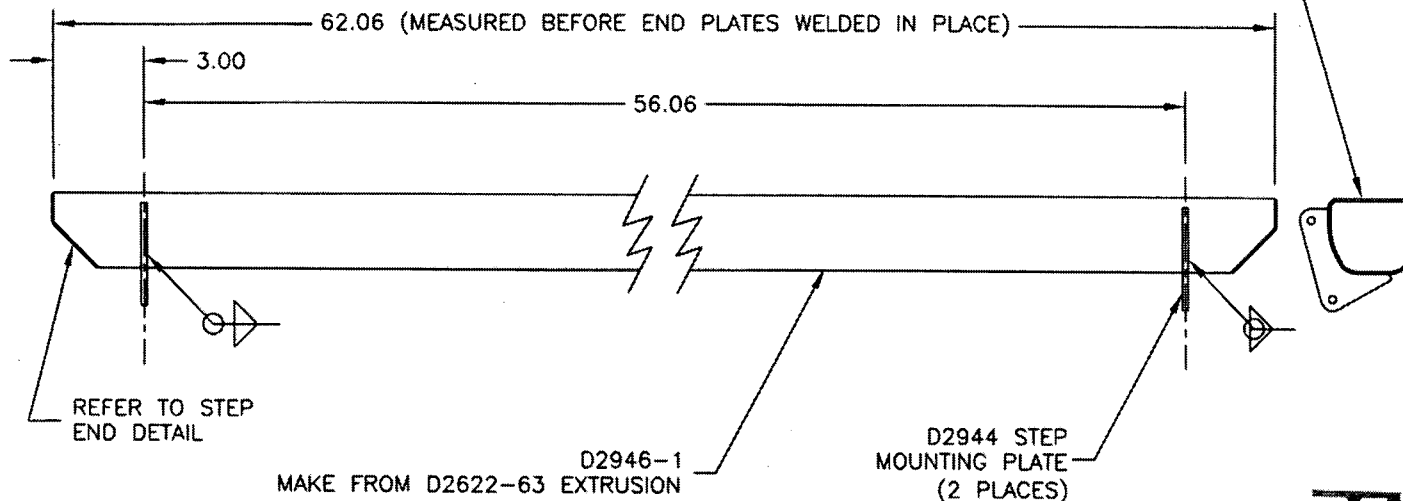
ulb
63024

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

APPLY BLACK ANTI-SKID
ON TOP SURFACE TO
BOTTOM OF TOP RADIUS



D2946-041 STEP ASSEMBLY

D2946 STEP ASSEMBLY

- 1) MAKE FROM D2622 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| DESIGN | DRAWN BY | DART AEROSPACE LTD |
|----------|-----------------------|-----------------------------|
| CP | PH | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. |
| PH | PH | D2946 |
| DATE | TITLE | REV. B |
| 05.11.14 | STEP ASSEMBLY | SHEET 1 OF 1 |
| A | NEW ISSUE | SCALE |
| 05.11.14 | UPDATE FINISHING NOTE | 1:6 |

RELEASED
05.11.28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

5. PARTS LIST

| Qty -111A | Qty -113 | Qty -115 | Qty -117A | Qty -119 | Qty -133 | Part Number | Description |
|--------------|-------------|-------------|--------------|-------------|-------------|---------------|---|
| X | | | | | 1 | D350-591-111A | Heli-Access-Step ™, Long Step – High Skid |
| | X | | | | 1 | D350-591-113 | Heli-Access-Step ™, Short Step – High Skid |
| | | X | | | 1 | D350-591-115 | Heli-Access-Step ™, Short Step – Low Skid |
| | | | X | | 1 | D350-591-117A | Heli-Access-Step ™, Pre-Flight Step |
| | | | | X | | D350-591-119 | Heli-Access-Step ™, Long Step – Low Skid |
| | | | | | X | D350-591-133 | Heli-Access-Step ™, Aft Maintenance Step |
| | 1 | | | | | D2310 | STEP ASSEMBLY (HIGH-SHORT) |
| 1 | | | | | | D2311 | STEP ASSEMBLY (HIGH-LONG) |
| | | 1 | | | | D2354 | STEP ASSEMBLY (LOW-SHORT) |
| | | | | 1 | | D2355 | STEP ASSEMBLY (LOW-LONG) |
| | | | | | 1 | D2946-041 | STEP ASSEMBLY (MAINTENANCE) |
| 4 | 2 | 2 | 2 | 2 | | D2171 | CLAMP |
| 4 | 2 | 2 | 2 | 2 | | D2182B035 | CUSHION |
| | | | | | 4 | D2230-1 | MOUNTING LUG |
| | | | | | 4 | D2230-3 | MOUNTING LUG |
| 8 | 4 | 4 | 4 | 4 | | D2274 | RADIUS BLOCK |
| | | | 1 | | | D2362-041 | SUPPORT BRACKET |
| 2 | 1 | | | 1 | | D2362-3 | SUPPORT BRACKET |
| | | 1 | | | | D2362-5 | SUPPORT BRACKET |
| 2 | 1 | 1 | 1 | 1 | 2 | D2856-400-720 | ABRASION STRIP |
| | | | | | 1 | D2945 | MOUNTING PLATE |
| 2 | 2 | 2 | | 2 | | AN3-37A | BOLT |
| | | | | | 2 | AN4-7A | BOLT |
| | | | | | 4 | AN4-11A | BOLT |
| | | | | | 8 | AN4-14A | BOLT |
| | | 4 | | | | AN4-16A | BOLT |
| 8 | 4 | | | 4 | | AN4-20A | BOLT |
| 1 | 1 | 1 | 4 | 1 | | AN4-22A | BOLT |
| 4 | 4 | 4 | | 4 | | AN960JD10 | WASHER |
| 10 | 6 | 2 | 4 | 6 | 14 | AN960JD416 | WASHER |
| | | 4 | | | | AN960JD416L | WASHER |
| 2 | 2 | 2 | | 2 | | MS21042L3 | NUT |
| 9 | 5 | 5 | 4 | 5 | 14 | MS21042L4 | NUT |

| Qty -121 | Qty -122 | Qty -123 | Qty -124 | Part Number | Description |
|-------------|-------------|-------------|-------------|---------------|---|
| X | | | | D350-591-121 | Heli-Access-Step ™, Short Step – High Skid, LH |
| | X | | | D350-591-122 | Heli-Access-Step ™, Short Step – High Skid, RH |
| | | X | | D350-591-123 | Heli-Access-Step ™, Short Step – Low Skid, LH |
| | | | X | D350-591-124 | Heli-Access-Step ™, Short Step – Low Skid, RH |
| 1 | | | | D2351-041 | STEP ASSEMBLY (HIGH-SHORT, LH) |
| | 1 | | | D2351-042 | STEP ASSEMBLY (HIGH-SHORT, RH) |
| | | 1 | | D2356-041 | STEP ASSEMBLY (LOW-SHORT, LH) |
| | | | 1 | D2356-042 | STEP ASSEMBLY (LOW-SHORT, RH) |
| 1 | 1 | 1 | 1 | D2230-1 | MOUNTING LUG |
| 1 | 1 | 1 | 1 | D2230-3 | MOUNTING LUG |
| 1 | 1 | 1 | 1 | D2856-400-720 | ABRASION STRIP |
| 2 | 2 | 2 | 2 | AN3-37A | BOLT |
| 3 | 3 | 3 | 3 | AN4-13A | BOLT |
| 4 | 4 | 4 | 4 | AN960JD10 | WASHER |
| 6 | 6 | 6 | 6 | AN960JD416 | WASHER |
| 2 | 2 | 2 | 2 | MS21042L3 | NUT |
| 3 | 3 | 3 | 3 | MS21042L4 | NUT |

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Revision: G

Date: 08.10.06

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-121/-122/-123/-124/-133 steps, customers have the option of installing D2732-030 cushions under the D2230-1/-3 clamps to accommodate varying crosstube diameters and to improve fit. It is also acceptable to use longer or shorter AN4 bolts, and/or extra AN960JD416 washers under the nut to ensure 1.5 to 4 threads in safety. See Figure 1 on sheet 2 of this service instruction for reference.

For D350-591-121/-122 steps at CHG 005, D350-591-123/-124 steps at CHG 004, and D350-591-133 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

| Qty -121 | Qty -122 | Qty -123 | Qty -124 | Qty -133 | Part Number | Description |
|-------------|-------------|-------------|-------------|-------------|--------------|---|
| X | | | | | D350-591-121 | Heli-Access-Step™, Short Step – High Skid, LH |
| | X | | | | D350-591-122 | Heli-Access-Step™, Short Step – High Skid, RH |
| | | X | | | D350-591-123 | Heli-Access-Step™, Short Step – Low Skid, LH |
| | | | X | | D350-591-124 | Heli-Access-Step™, Short Step – Low Skid, RH |
| | | | | X | D350-591-133 | Heli-Access-Step™, Aft Maintenance Step |
| 2 | 2 | 2 | 2 | 8 | D2732-030 | CUSHION |
| 2 | 2 | 2 | 2 | 8 | AN4-16A | BOLT |






The DSI-9459-011 kit is available for customers with earlier model D350-591-121/-122/-123/-124 steps. Longer AN4 bolts are provided to fasten the clamps. The DSI-9459-013 kit is available for customers with earlier model D350-591-133 steps.

| Qty -011 | Qty -013 | Part Number | Description |
|-------------|-------------|--------------|--|
| X | | DSI-9459-011 | Rubber Cushion Kit (for -121/-122/-123/-124 steps) |
| | X | DSI-9459-013 | Rubber Cushion Kit (for -133 steps) |
| 2 | 8 | D2732-030 | CUSHION |
| 2 | 8 | AN4-16A | BOLT |

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 09.06.24
CERT. NO.: SH92-6
ISSUE NO.: 11

| | | | |
|------------|---|--|--------------|
| B | AN4-16A WAS -17A FOR -013/-133 KIT | CP | 09.06.24 |
| A | NEW ISSUE | CP | 09.04.17 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN |  | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN |  | | |
| CHECKED |  | DRAWING NO. | REV. B |
| MFG. APPR. | N/A | DSI 9459 | SHEET 1 OF 2 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | OPTIONAL CLAMP MODIFICATIONS | NTS |
| DATE | 09.06.24 | <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |